

Wednesday, July 08, 2015 3:14:25 PM

Page 1

2-Deburr as required

DAS
20
9.89

1507-14

**DAS
20
9-89**

15-07-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 134435

Wednesday, July 08, 2015 3:14:25 PM

134435

Page 2

Item ID: D3901-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 7/05/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				10	Ø		DAS 20 9-89 15-07-15
120									
QC	Memo	0.00							
Quality Control	***EXTRA MATERIAL WILL BE CUT ON ASSEMBLY***								
130	QC8- Inspect parts - second check	0.00				10	Ø		DAS 44 9-89 15/07/15
130									
QC	Memo	0.00							
Quality Control	***EXTRA MATERIAL WILL BE CUT ON ASSEMBLY***								
140	Identify as per dwg & Stock Location: <u>W/A001</u>	0.00				10	Ø	15-7-15	
140									
Packaging	Memo	0.00							
Packaging	LOCATION: WA001								

DQA: _____ Date: _____



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Page 3

ML5 JUL 15 2015

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Picklist Print

Wednesday, July 08, 2015 3:14:24 PM

Page 1

Work Order ID: 134435

134435

Parent Item: D3901-3

D3901-3

Parent Item Name: Bar

Start Date: 7/05/15

Required Date: 7/07/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
on cnc JFS 12/02/13 verified by:JLM

IPP RevB: Now

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	568.4960	5.573	58.66316			DAS
M304B0 250x0 500									**	60.000'			20
304 BAR .250 x .500													9-89 15-07-14

Location

Loc Qty

Loc Code

MAT009

568.496

m129366

28.696

m131748

79.1

m132332

460.7

60.000'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : _____					

SHOP COPY
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 UNCONTROLLED COPY
 SUBJECT OF THIS DRAWING

NO. 134435 MLJ
 15-07-10

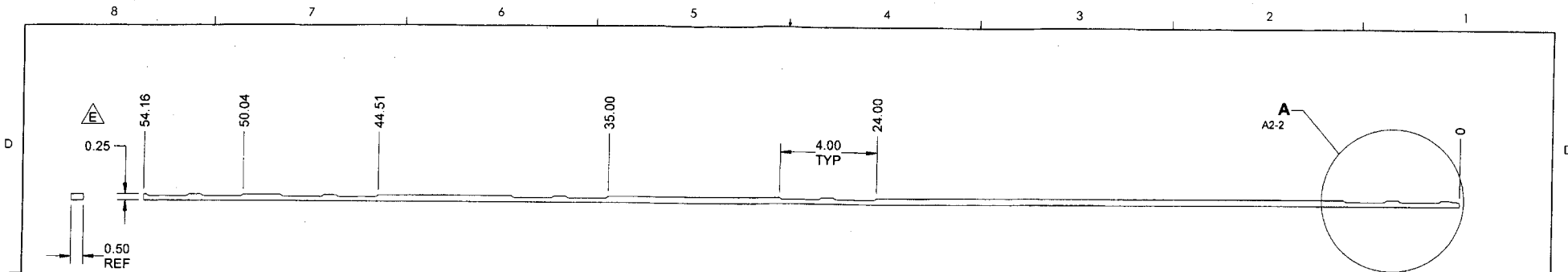
D3901-1 BAR

D3901-3 BAR

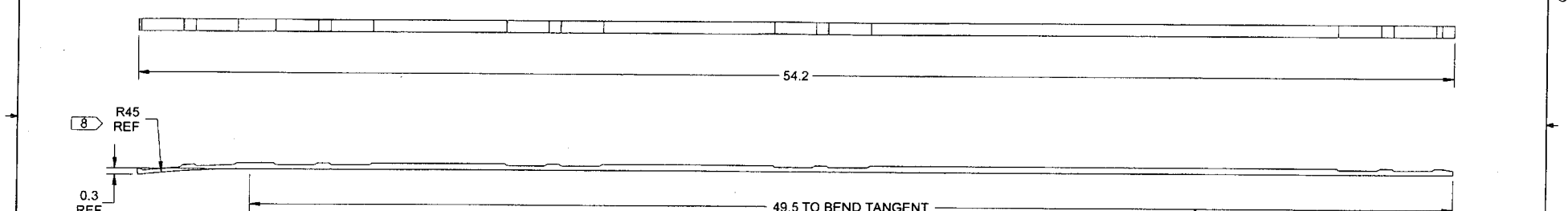
D3901-5 BAR

RELEASED
 2012-09-04
 MP

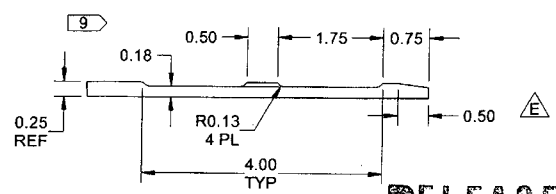
E	CHANGE LOCATION OF END POCKETS ON -1/3-5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4)	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/3-5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4); SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2); ADD POCKET TO -1 (ZN D6-2)	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1FI-SF FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/3-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D3901	SHEET 1 OF 4
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	BAR	NTS
DATE	12.08.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3901-1F BAR FLAT PATTERN



**D3901-1 BAR
(MAKE FROM D3901-1F)**

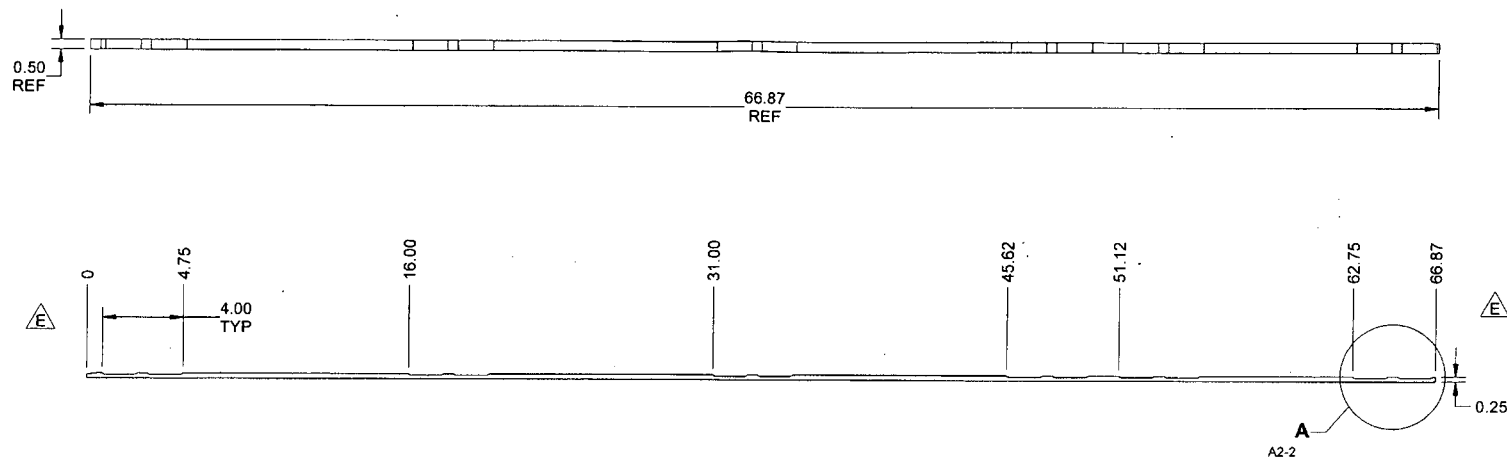


DETAIL A
D1-2
B2-3
D1-4

RELEASED
2012-09-01

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.78 lbs
 - 8) FORM TO FIT WEARPLATE
 - 9) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	JS	DRAWING NO.	REV. E
MFG. APPR.	ST	D3901	SHEET 2 OF 4
APPROVED	142	TITLE	SCALE
DE APPR.	142	BAR	NTS
DATE	12.08.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



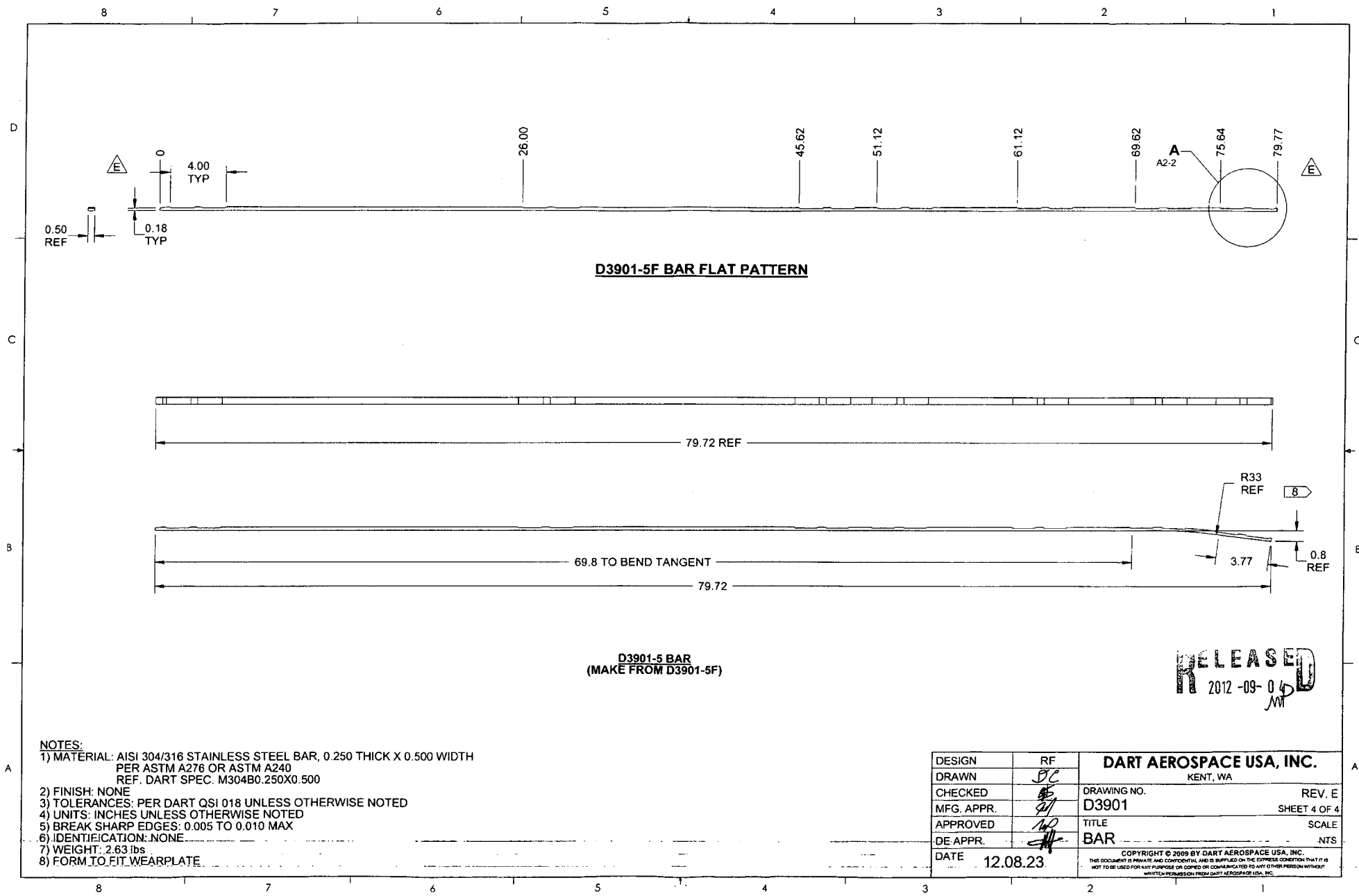
D3901-3 BAR

RELEASED
2012-09-04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK-SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.21 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D3901	SHEET 3 OF 4
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	BAR	NTS
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D3901-5F BAR FLAT PATTERN

**D3901-5 BAR
(MAKE FROM D3901-5F)**

RELEASED
2012-09-04
MM

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.63 lbs
 - 8) FORM TO FIT WEARPLATE

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	SE	DRAWING NO.	REV. E
MFG. APPR.	ST	D3901	SHEET 4 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BAR	NTS
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